

# Work Order ID 101393

May-09-13 1:47:44 PM

**\*101393\***

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Item ID: D4617-041  
Revision ID:  
Item Name: Emergency Escape Ladder

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 5/09/13 Start Qty: 1.00 **\*1\***  
Required Date: 5/23/13 Req'd Qty: 1.00 **\*1\***

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: MCS Date: 1305-09 Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4617	B

100	0.00
-----	------

**\*100\***

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

BEND RAIL AS PER DWG AND TO FIT PROFIL OF WELDING JIG DT9803  
(ON LENGTH OF TUBE, 20 FEET MAKES 2 RAILL)

1 Q 14-4-27

110

Weld per dwg A/R 4130 rod Batch: 112775 0.00

**\*110\***

Large Fab

Large Fab

Memo

0.00

1- CUT STEPS AS PER DWG AND PREP FOR WELDING

2- CUT RAIL

3- INSTALL PARTS ON WELDING JIG DT9803 AND WELD AS PER DWG

1 Q 14-4-27

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Stop \*NS2\*

**Cust Item ID:**  
**Customer:**

Stop **\*NR2\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

[illegible]

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Item ID: D4617-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Emergency Escape Ladder

Start Date: 5/09/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/23/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> Powdercoat Powder Coating	Fire Red(Ref4.3.5.10) per QSI005 4.3 <i>m 113643</i> Memo START TIME: <i>11:20</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:50</i>	0.00  0.00				<i>1</i>	<i>0</i>	<i>14-5-13</i>	<i>DAS 30 9-89</i>
160 <b>*160*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<i>L</i>			<i>14/07/02</i>
170 <b>*170*</b> Small Fab Small Fab	 Memo 1- Assemble clamps, clamps cover and tube caps to ladder as per dwg 2- Install decals as per dwg	0.00  0.00				<i>1</i>			<i>FF 14-07-04</i>

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Item ID: D4617-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Emergency Escape Ladder

Stop \*NS2\*

Start Date: 5/09/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/23/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

\*180\*

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location:

0.00

\*190\*

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

QC

Memo

0.00

Quality Control

DAS  
27  
9-89  
14714

PPP 117100

1x 1477 DAS  
26  
9-89

MLJ 14-07-08  
ME 14-7-7

# Picklist Print

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Work Order ID: 101393

\*101393\*

Parent Item: D4617-041

\*D4617-041\*

Parent Item Name: Emergency Escape Ladder

Start Date: 5/09/13

Required Date: 5/23/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.035

Purchased

No

100

f

286.4900

20

21.05263

**\*M4130NT0 750W 035\***

\*\*

14-4-29

4130 RD TUBE .750 X .035W

Location

Loc Qty

Loc Code

MAT032

70.49

121250

70.49

MAT033

216

121910

216

M4130NT0.750W.035

Purchased

No

110

f

286.4900

5.06

5.326316

**\*M4130NT0 750W 035\***

\*\*

14-4-29

4130 RD TUBE .750 X .035W

Location

Loc Qty

Loc Code

MAT032

70.49

121250

70.49

MAT033

216

121910

216

D4617-045

Manufactured

No

170

Each

4.0000

4

4

**\*D4617-045\***

\*\*

FF 14-07-04

Clamp Assembly

Location

Loc Qty

Loc Code

ST115

B95579

4

85918

4

4

# Picklist Print

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Work Order ID: 101393

\*101393\*

Parent Item: D4617-041

\*D4617-041\*

Parent Item Name: Emergency Escape Ladder

Start Date: 5/09/13

Required Date: 5/23/13

Start Qty: 1.00

Required Qty: 1.00

D4618-041

Manufactured No

170

Each

14.0000

4

4

\*D4618-041\*

Clamp Assembly Cover

\*\*

FF 14-07-04

Location

Loc Qty

Loc Code

ST187

14

83121

2

84410

12

4

D4621-1

Manufactured No

170

Each

14.0000

2

2

\*D4621-1\*

Decal

\*\*

FF 14-07-04

Location

Loc Qty

Loc Code

ST115

14

83682

6

95979

8

2

D4621-3

Manufactured No

170

Each

24.0000

1

1

\*D4621-3\*

Decal

\*\*

FF 14-07-04

Location

Loc Qty

Loc Code

ST115

24

83683

21

95580

3

1

D4625-1

Manufactured No

170

Each

85.0000

4

4

\*D4625-1\*

Tube Cap

\*\*

FF 14-07-04

Location

Loc Qty

Loc Code

ST115

85

83122

85

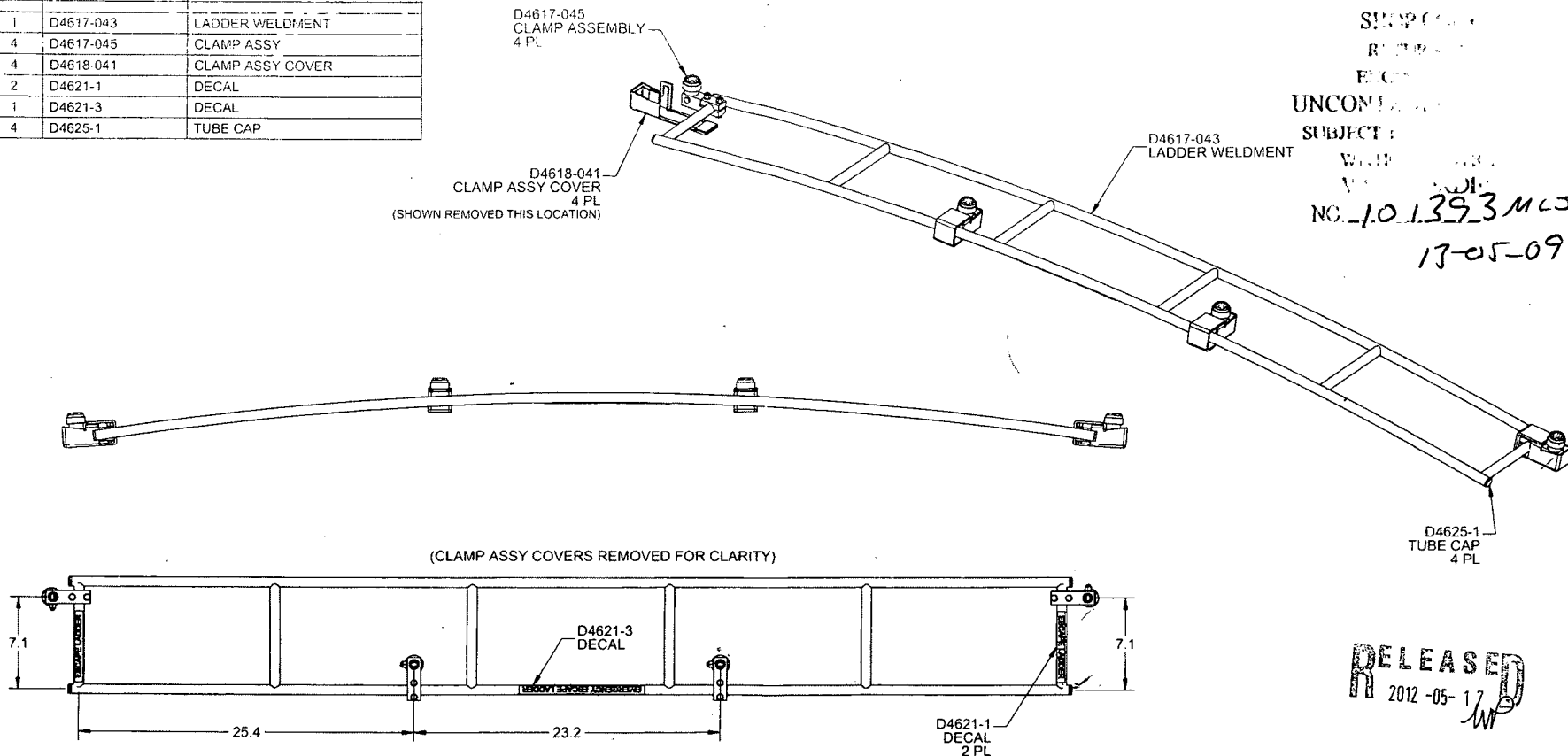
4

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Shop Packet Print

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ITEM	QTY	P/N	DESCRIPTION
+	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP



**D4617-041 EMERGENCY ESCAPE LADDER**

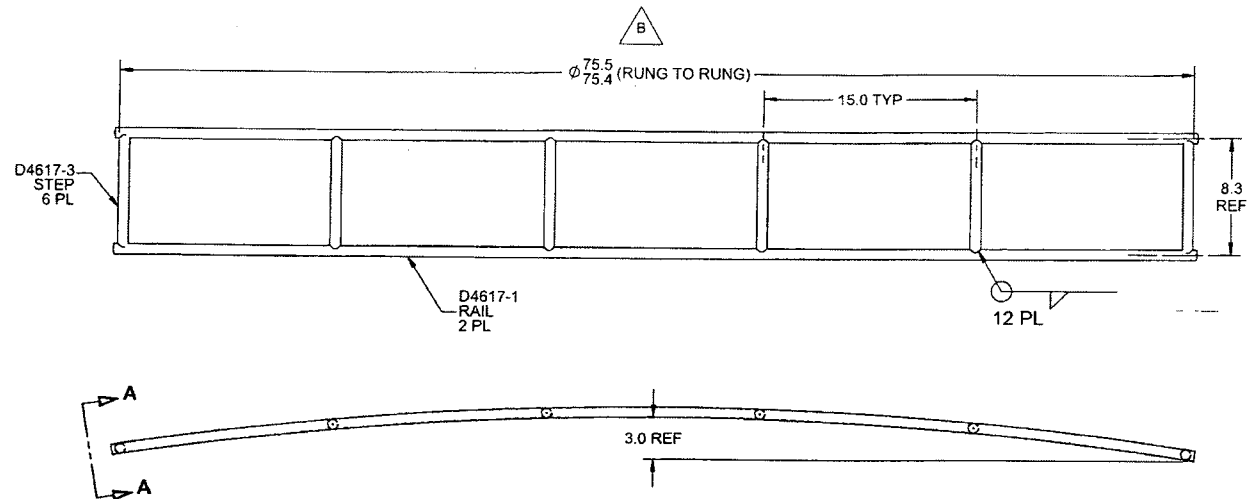
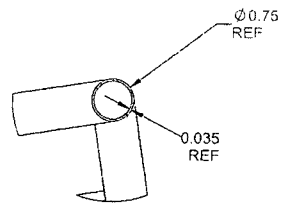
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI044 6.6
- 7) WEIGHT: 6.48 lbs

B	75 4-75.5 WAS 75.7 (C4-2) WASHER WAS NAS1149C0463R, QTY 3 ON SHT 4. 0.753-0.756 WAS 0.750-0.753 (B4-S)	RP	12.05.01
A	NEW ISSUE	RP	12.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RP		
DRAWN	RP		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.05.01		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4617</b> TITLE <b>EMERGENCY ESCAPE LADDER</b> REV. B SHEET 1 OF 5 SCALE NTS <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

RELEASED  
2012-05-17

STAMP  
RECEIVED  
UNCONFIDENTIAL  
SUBJECT:  
WASHER WAS NAS1149C0463R  
VOLUME  
NO. 10.1393 MJS  
17-05-09

**D4617-043 LADDER WELDMENT**

**RELEASED**  
2012-05-17

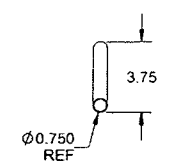
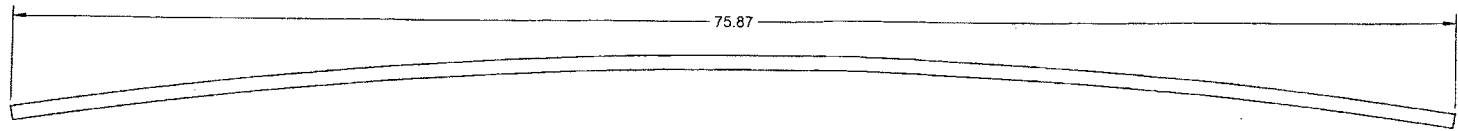
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 4.5 lbs
- 8) WELDING: PER DART QSI 004

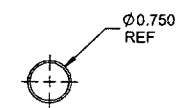
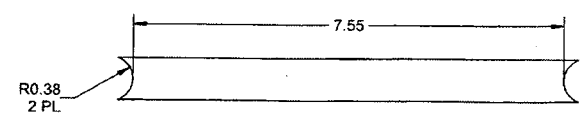
DESIGN	RP	<b>DART AEROSPACE LTD</b>	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4617</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>EMERGENCY ESCAPE LADDER</b>	NTS
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101393



**D4617-1 RAIL**



**D4617-3 STEP**

RELEASED  
2012-05-17

- NOTES:**
- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T6736  
OR AMS6371, 6360, 6361, 6362, 6373, 6374  
REF DART SPEC M4130NT0.750W.035
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER DART QSI044 6.6
  - 7) WEIGHT: D4617-1 1.7lbs  
D4617-3 0.17lbs

DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO. <b>D4617</b>	REV. B
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>EMERGENCY ESCAPE LADDER</b>	NTS
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